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RB KIT 407M-09
Job Sheet 203471



Part No: RB KIT 407M-09

Job Qty: 10 pcs

Part Name: Gauge Pin .0800" dia.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No:

Due Date: 12/3/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

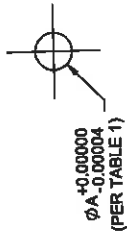
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	12/3/19		0.00	1.25	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
120	QC 5	10 pcs	12/3/19		0.00	0.00	QC 5 - 10		GP 19-11-20
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	10 pcs	12/3/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

Plex 11/20/19 10:05 AM Dart.lajeunesse.marie

				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B	DA 21	
				Packaging 3 - 6 - B4B	8-89	
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140	QC 21 - SA	10 pcs	12/3/19	0.00 0.00	QC 21 - SA - 21	DA 21
					QC 21 - SA - 70	8-89
					QC 21 - SA - 53	
Part Op 100 - 1-Cut pin in half. 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion. Descriptions: 4-Package as per note 10. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
21135A54	Plug Gauge	5 Ea (.5 ea)	100-Small Fab - 1	151962		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Small Fab - 1	21135A54	5	34	0		
Part Specifications						
Specifications could not be found.						



**TABLE 1
GAUGE PIN DIMENSIONS**

PART NUMBER	ϕA	B	PURCHASE PART NUMBER (McMASTER CARR)
RB KIT 407M-01	$\phi 0.2400$	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	$\phi 0.4000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	$\phi 0.5400$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	$\phi 0.6800$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	$\phi 0.8600$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	$\phi 0.9600$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	$\phi 1.0800$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	$\phi 1.2000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	$\phi 1.4400$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-19	$\phi 1.6000$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	$\phi 1.6000$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-23	$\phi 1.7280$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	$\phi 1.7280$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-27	$\phi 1.8000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-29	$\phi 1.8000$	1.00"	21135A55 OR EQUIV.
RB KIT 407M-31	$\phi 1.9200$	1.00"	21135A55 OR EQUIV.

RB KIT 407M-01 THRU -31 ϕ .XXXX. CLASS X PLUG NO-GO GAUGE

NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION

2) FINISH: N/A

3) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$

X.XX = $\pm 0.01"$ / $\pm 0.5"$

X.XXX = $\pm 0.005"$ / $\pm 0.1"$

X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

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WORK ORDER
NO. 203471 M3
(5-11-20)

DESIGN	KPT	DART AEROSPACE LTD	REV. D
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	SHEET 3 OF 8
MFG. APPR.		RB KIT 407M	
APPROVED	DP	TITLE	SCALE
	Wp	SPLINE MEASURING KIT	N/A
DATE		1/17/2019	

COMPONENT IS THIS BY DART AEROSPACE LTD
THE FOLLOWING INFORMATION IS FOR YOUR INFORMATION ONLY
IT IS NOT TO BE USED FOR ANY OTHER PURPOSES
WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

MRB (QS1042)

Date : _____ Sequence #: _____

QTY Affected : _____

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Root Cause

Operator ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Other/Details: